Work Order Thursday, May 19									,	-		Page 1
Item ID: I Revision ID:	D3490-1			Accept					Setup	Start		
Item Name:	Cross Bolt Spa	acer						, -		Stop		
Start Date: 5 Required Date: 5 Reference:	5/19/2011 5/25/2011	Start Qty: 60.00 Req'd Qty: 60.00		1551	Cust Item I Customer:	D:	:					
	Process Pla	n:	Date: 1/-05-19	7 Tooling:	Da	nte:			Run	Start		
	QC:	7	Date:	_ SPC (Y/N):	Da	ate:				Stop		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr			1111	-						
D3490	Rev	A										
100 Hardinge		Hardinge CNC LATHE S	SMALL	0.00				64	Q	6_		
Hardinge CNC Lathe	Small	DWG REV:	PER FOLIO FA628 & D A AS REQUIRED		/(
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00				64	a	b		
QC		Мето		0.00								
Quality Control			(2	11/6/1							0	
120		QC8- Inspect parts - seco	and check	0.00	(1 - C -	- \		af	<u>.</u>	6		
QC Quality Control		Мето		0.00	(, -	,		<u>~/</u>		<i></i>		

W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								:
		- 						
Davi Na	_	DAD #	F-114 O-4		NOD. Van A	I- DOA-	Data	
Part No		PAR #:						
·········	Hes	solution:					Date: _	
NCR:		· ·	WORK ORL	DER NON-CONFORMA	ANCE (NCH)			
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
	0121	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
						4		
							,	
						1		

Work Order ID 69823

Thursday, May 19, 2011 2:33:50 PM



Page 2

Item ID:

D3490-1

Accept



Setup Start

Stop



Revision ID:

Item Name:

Cross Bolt Spacer

Start Date:

Required Date: 5/25/2011

5/19/2011

Start Qty: 60.00

Req'd Qty: 60.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start



Stop

Sequence ID/

Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Locatio

Memo

STOCK IN SKIDTUBE CELL

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Insp. Reject Number

Stamp

140

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

	•								
W/O:			WC	RK ORDER CHANG	GES				
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		ž.							
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
	Re	esolution:	Disposition	n:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORDI	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			ction B	Verifica		Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		tion C	Chief Eng	QC Inspector
				53333333					

Picklist Print

Thursday, May 19, 2011 2:33:57 PM

Work Order ID: 69823

Parent Item:

D3490-1

Parent Item Name:

Cross Bolt Spacer



Start Date: 5/19/2011

Required Date: 5/25/2011

Page 1

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP Rev:A New Issue 06-03-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.500W.049		Purchased	No			100	f	365.6670	0.266	16.8			
					•					27	\ /	1)6)	1

6061-T6 RD Tube .500 x.049W

Loc Code Location Loc Qty MAT014 365.667 117270 365.667

W/O:			W	ORK ORDER CHANG	iES					
DATE	STEP	PRO	OCEDURE CHA	NGE	В	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		1000000	-		-				1 rod ivigi	
Part No		PAR #:	Fault Cate	gory:	NCR: \	es N	lo DQ /	1	Date:	
		lution:								
NCR:		-	WORK ORD	ER NON-CONFORM	ANCE (N	ICR)				
DATE	STEP	Description of NC		Corrective Action Section			Verific	ation	Approval	Approval
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		on C	Chief Eng	QC Inspector
										·
										-
		-						_		

DART AEROSPACE LTD	Work Order:	69823
Description: Crossbolt Spacer	Part Number:	D3490-1
Inspection Dwg: D3490 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500	+0.006/-0.001	1,500)			5)-9	
0.049	+/-0.010	-048				
Ø0.402	+0.006/-0.001	0.405				
3.085	+0.030/-0.000	3,030	//			
0.050 x 45°	+/-0.010	,050 X45°				
				•		

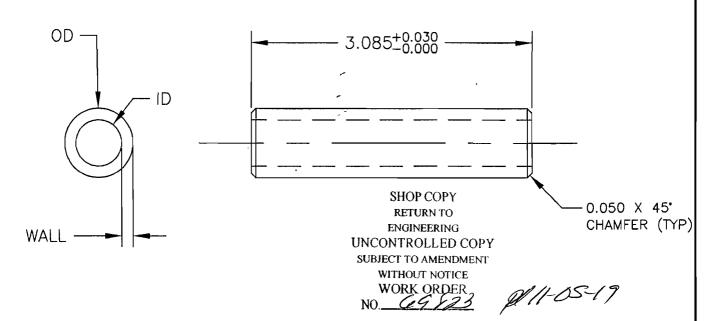
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 11/6/(Date: [. 6 .	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.10.06	New Issue	KJ/JLM	
В	08.06.02	Dimensions and tolerances revised	KJ/DD 1.A	
C	08.10.07	0.050 x 45° dimension revised	KJ/DD O	77

W/O:	•		W	ORK ORDER CHANGES	3				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									,
Cog.		*				*			
Part No		PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Dispositi	on:	QA: N/C C	osed:		Date: _	
NCR:		V	VORK ORE	ER NON-CONFORMAN	CE (NCF	₹)			
			Description of NC Corrective Action Section B						
DATE	STEP	Description of NC					cation	Approval	Approval
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sign &	Secti	cation ion C	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A		Action Description	Sign 8	Secti		Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A		Action Description	Sign 8	Secti		Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A		Action Description	Sign 8	Secti		Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A		Action Description	Sign 8	Secti		Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A		Action Description	Sign 8	Secti		Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A		Action Description	Sign 8	Secti		Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A		Action Description	Sign 8	Secti		Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A		Action Description	Sign 8	Secti		Approval Chief Eng	Approval QC Inspector



DES	PH	DRAWN BY	DART	AEROSPA		INC.
CHE	CKED 🚜	APPROVED MI	DRAWING NO.			REV. A
	#	-4	D3490		SH	EET 1 OF 1
DAT	Ε	•	TITLE	_		SCALE
06	.01.04		CROSS BO	LT SPACER		NTS
Α		06.01.04	NEW ISSU	JE		



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

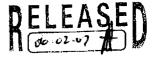
D3490-1/-3/-5 CROSS BOLT SPACER

1) MATERIAL:

ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)

2) ALL DIMENSIONS ARE IN INCHES

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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W/O:	-		V	ORK ORDER CHANGES				
DATE	STEP	PROC	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
								4 4 1 1
Part No: PAR #:		_ Fault Ca	tegory: f	ICR: Yes No DQA: Date:				
Resolution:			_ Disposit	ion: (QA: N/C Closed: Date:			
NCR:		· ~ W	ORK OR	DER NON-CONFORMAN	CE (NCR)			
DATE ST	STEP	Description of NC Section A	Corrective Action Section B			Verification		Approval
	OIL!		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
·								
							-	
1								